

# Work Order ID 78142

December-29-11 10:35:38 AM

**\*78142\***

Page 1

Item ID: D2661-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, RH Fwd Aft Out 206  
 Start Date: 29/12/2011 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 06/02/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.J Date: 11/12/29 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| <b>Draw Nbr</b>                | <b>Revision Nbr</b>      |                      |         |        |              |               |               |                  |                |
| D2661                          | Rev E                    |                      |         |        |              |               |               |                  |                |

100 0.00  
**\*100\*** HAAS CNC VERTICAL MACHINING #1 F.K 12/01/21 10 9  
 HAAS 1 Memo 0.00  
 HAAS CNC vertical machine #1 Program part number and batch number  
 MACHINE AS PER DWG AND FOLIO FB07I  
 FOLIO REV: AA  
 DWG REV: E

110 0.00  
**\*110\*** CONVENTIONAL MILLING MACHINE F.K 12/01/21 10 8  
 Mill Conv Memo 0.00  
 Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 78142

December-29-11 10:35:38 AM

**\*78142\***

Page 2

Item ID: D2661-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, RH Fwd Aft Out 206  
 Start Date: 29/12/2011 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 06/02/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                      | Operation<br>Description                            | Set Up/<br>Run Hours | Tool ID | Tool #   | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---|---|----------------------|---------|----------|--------------|---------------|---------------|------------------|----------------|
| 120<br><b>*120*</b><br>QC<br>Quality Control        | QC2- Inspect parts off machine FAI/FAIB<br><br>Memo | 0.00<br><br>0.00     | F.K.    | 12/01/21 |              | 10            | /             |                  |                |
| 130<br><b>*130*</b><br>QC<br>Quality Control        | QC8- Inspect parts - second check<br><br>Memo       | 0.00<br><br>0.00     | and     | 12/01/23 |              | 10            | /             |                  |                |
| 140<br><b>*140*</b><br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>Memo | 0.00<br><br>0.00     |         |          |              | 10            | BR            | 12-1-24.         |                |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**\*78142\***

December-29-11 10:35:38 AM

**\*N900040100\***

Setup Start **\*NS1\***

Stop \*NS2\*

**Start Date:** 29/12/2011      **Start Qty:** 10.00

**\*10\***

**Cust Item ID:****Required Date:** 06/02/2012      **Req'd Qty:** 10.00

**\*10\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|     |  |      |
|-----|--|------|
| 150 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 |
|-----|--|------|

**\*150\***

### Powdercoat

## Powder Coating

## Memo

START TIME:

FINISH TIME:

0.00

OVEN TEMPERATURE:

|     |                          |      |
|-----|--------------------------|------|
| 160 | QC3- Inspect Part Finish | 0.00 |
|-----|--------------------------|------|

**\*160\***

QC

## Quality Control

## Memo

0.00

|     |  |      |
|-----|--|------|
| 170 | Identify as per dwg & Stock Location: <u>435</u> | 0.00 |
|-----|--|------|

**\*170\***

### Packaging

## Packaging

## Memo

0.00

10X Ø M/L 12/01/25

Powder Coating

Memo

START TIME: 2:40 0.00

FINISH TIME: 3:10

10 BLB-1-75.

12/12/2020

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 78142****\*78142\***

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December-29-11 10:35:38 AM

Item ID: D2661-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Saddle, RH Fwd Aft Out 206  
Start Date: 29/12/2011 Start Qty: 10.00 **\*10\*** Cust Item ID:  
Required Date: 06/02/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180                            | QC21- Final Inspection - Work Order Release | 0.00                 |         |        |              |               |               |                  |                |
| <b>*180*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

12/1/26  
12.01.26

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



# Picklist Print

December-29-11 10:35:43 AM

Page 1  
T

Work Order ID: 78142

\*78142\*

Parent Item: D2661-2

\*D2661-2\*

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 29/12/2011

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house  
processEC IPP REV:D  
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD  
IPP Rev:D As per Rev D 07-03-19 JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-003                       |                        | Manufactured  | No          |                     |                  | 100             | Each               | 92.0000        | 1           | 10           |               |                |        |
| *D6101-003*                     |                        |               |             |                     |                  |                 |                    |                | **          |              |               |                |        |

Saddle Billet, 7075

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT040   | 16      |          |
| 73775    | 2       |          |
| 73780    | 7       |          |
| MAT042   | -7      |          |
| MAT044   | 83      |          |
| 73769    | 1       |          |
| 76837    | 82      |          |
| 77562    | 10      |          |

10 F.K 12/01/21

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|  |                             |
|--|-----------------------------|
| <b>DART AEROSPACE LTD</b>                            | <b>Work Order:</b> 78142    |
| <b>Description:</b> 206 Saddle, Outboard, Right side | <b>Part Number:</b> D2661-2 |
| <b>Inspection Dwg:</b> D2661 Rev. D                  | <b>Page 1 of 1</b>          |

Inspect dimensions highlighted on inspection sheet drawing and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |        |        | By     | Date |
|---------------|-------|-------|----------------|----------------------------|-------|--------|--------|--------|------|
|               |       |       |                | 1                          | 2     | 3      | 4      |        |      |
| A             | 0.100 | 0.140 |                | .135                       | .134  | .132   | .134   | .134   |      |
| B             | 0.100 | 0.140 |                | .124                       | .124  | .124   | .124   | .120   |      |
| C             | 1.125 | 1.145 |                | 1.134                      | 1.134 | 1.1344 | 1.1342 | 1.133  |      |
| D             | 0.615 | 0.685 |                | .675                       | .675  | .675   | .675   | .675   |      |
| E             | 0.240 | 0.260 |                | .253                       | .253  | .253   | .252   | .254   |      |
| F             | 1.313 | 1.343 |                | 1.325                      | 1.328 | 1.328  | 1.328  | 1.323  |      |
| G             | 0.210 | 0.230 |                | .226                       | .226  | .226   | .227   | .226   |      |
| H             | 0.100 | 0.180 |                | .135                       | .135  | .135   | .135   | .135   |      |
| I             | 2.470 | 2.510 |                | 2.490                      | 2.490 | 2.490  | 2.490  | 2.490  |      |
| J             | 1.565 | 1.585 |                | 1.576                      | 1.572 | 1.571  | 1.5717 | 1.5625 |      |
| K             | 0.235 | 0.240 |                | .236                       | .236  | .236   | .236   | .236   |      |
| L             | 0.100 | 0.120 |                | .111                       | .111  | .111   | .111   | .111   |      |
| M             | 0.990 | 1.010 |                | 1.000                      | 1.000 | 1.000  | 1.000  | 1.000  |      |
| N             | 0.510 | 0.515 |                | .512                       | .512  | .512   | .512   | .512   |      |
| O             | 5.990 | 6.010 |                | 6.000                      | 6.000 | 6.000  | 6.000  | 6.000  |      |
| P             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250  | 1.250  | 1.250  |      |
| Q             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500  | 2.500  | 2.500  |      |
| R             | 0.313 | 0.318 |                | .314                       | .314  | .314   | .314   | .314   |      |
| S             | 0.315 | 0.322 |                | .316                       | .316  | .316   | .316   | .316   |      |
| T             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500  | 2.500  | 2.500  |      |
| U             | 1.357 | 1.367 |                | 1.362                      | 1.362 | 1.362  | 1.362  | 1.362  |      |
| V             | 0.787 | 0.807 |                | .797                       | .797  | .797   | .796   | .797   |      |
| W             | 0.540 | 0.560 |                | .549                       | .550  | .550   | .550   | .550   |      |
| X             | 1.674 | 1.684 |                | 1.679                      | 1.679 | 1.679  | 1.679  | 1.679  |      |
| Y             | 0.257 | 0.262 |                | .260                       | .260  | .260   | .260   | .260   |      |
| Z             | 0.912 | 0.932 |                | .922                       | .922  | .921   | .921   | .921   |      |
| AA            | 0.490 | 0.510 |                | .499                       | .498  | .499   | .497   | .497   |      |
| AB            | 0.178 | 0.198 |                | .188                       | .188  | .188   | .188   | .188   |      |
| AC            |       |       |                |                            |       |        |        |        |      |
| AD            |       |       |                |                            |       |        |        |        |      |
| AE            |       |       |                |                            |       |        |        |        |      |
| AF            |       |       |                |                            |       |        |        |        |      |
| Accept/Reject |       |       |                |                            |       |        |        |        |      |

|                 |                 |
|-----------------|-----------------|
| Measured by: FK | Audited by: cmf |
| Date: 12/01/21  | Date: 12/01/23  |

| Rev | Date     | Change  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue   | RF         |          |
| B   | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF         |          |
| C   | 99.11.11 | Added Dim. R-T                                    | RF         |          |
| D   | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686         | KJ/RF      |          |
| E   | 06.07.05 | Revised per drawing revision C                    | KJ/JLM     |          |
| F   | 07.03.21 | Revised per drawing revision D                    | KJ/JLM     |          |
| G   | 11.10.13 | Dimensions C and F revised                        | KJ         |          |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|  |  |                             |
|--|--|-----------------------------|
| <b>DART AEROSPACE LTD</b>                            |  | <b>Work Order:</b> 78142    |
| <b>Description:</b> 206 Saddle, Outboard, Right side |  | <b>Part Number:</b> D2661-2 |
| <b>Inspection Dwg:</b> D2661 Rev. <u>DE</u>          |  | <b>Page 1 of 1</b>          |

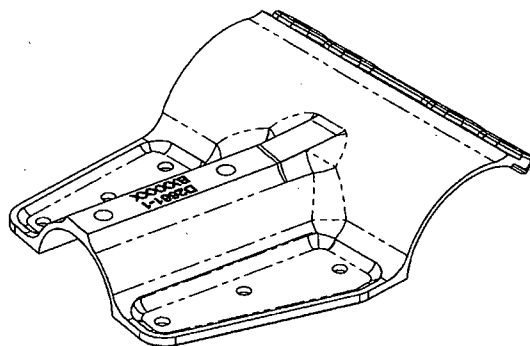
Inspect dimensions highlighted on inspection sheet drawing and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |        |        |        |        | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|--------|--------|----|------|
|               |       |       |                | 6 1                        | 7 2    | 8 3    | 9 4    | 10 5   |    |      |
| A             | 0.100 | 0.140 |                | .130                       | .129   | .133   | .133   | .133   |    |      |
| B             | 0.100 | 0.140 |                | .124                       | .124   | .122   | .122   | .121   |    |      |
| C             | 1.125 | 1.145 |                | 1.137                      | 1.1378 | 1.134  | 1.1337 | 1.1328 |    |      |
| D             | 0.615 | 0.685 |                | .675                       | .675   | .675   | .675   | .675   |    |      |
| E             | 0.240 | 0.260 |                | .252                       | .249   | .253   | .253   | .253   |    |      |
| F             | 1.313 | 1.343 |                | 1.323                      | 1.323  | 1.325  | 1.324  | 1.323  |    |      |
| G             | 0.210 | 0.230 |                | .225                       | .225   | .225   | .226   | .226   |    |      |
| H             | 0.100 | 0.180 |                | .135                       | .135   | .135   | .135   | .135   |    |      |
| I             | 2.470 | 2.510 |                | 2.490                      | 2.490  | 2.490  | 2.490  | 2.490  |    |      |
| J             | 1.565 | 1.585 |                | 1.5728                     | 1.5714 | 1.5695 | 1.5701 | 1.5687 |    |      |
| K             | 0.235 | 0.240 |                | .236                       | .236   | .236   | .236   | .236   |    |      |
| L             | 0.100 | 0.120 |                | .111                       | .111   | .111   | .111   | .111   |    |      |
| M             | 0.990 | 1.010 |                | 1.000                      | 1.000  | 1.000  | 1.000  | 1.000  |    |      |
| N             | 0.510 | 0.515 |                | .512                       | .512   | .512   | .512   | .512   |    |      |
| O             | 5.990 | 6.010 |                | 6.000                      | 6.000  | 6.000  | 6.000  | 6.000  |    |      |
| P             | 1.245 | 1.255 |                | 1.250                      | 1.250  | 1.250  | 1.250  | 1.250  |    |      |
| Q             | 2.495 | 2.505 |                | 2.500                      | 2.500  | 2.500  | 2.500  | 2.500  |    |      |
| R             | 0.313 | 0.318 |                | .314                       | .314   | .314   | .314   | .314   |    |      |
| S             | 0.315 | 0.322 |                | .316                       | .316   | .316   | .316   | .316   |    |      |
| T             | 2.495 | 2.505 |                | 2.500                      | 2.500  | 2.500  | 2.500  | 2.500  |    |      |
| U             | 1.357 | 1.367 |                | 1.362                      | 1.362  | 1.362  | 1.362  | 1.362  |    |      |
| V             | 0.787 | 0.807 |                | .797                       | .797   | .797   | .797   | .797   |    |      |
| W             | 0.540 | 0.560 |                | .549                       | .549   | .549   | .547   | .548   |    |      |
| X             | 1.674 | 1.684 |                | 1.679                      | 1.679  | 1.679  | 1.679  | 1.679  |    |      |
| Y             | 0.257 | 0.262 |                | .260                       | .260   | .260   | .260   | .260   |    |      |
| Z             | 0.912 | 0.932 |                | .922                       | .922   | .922   | .922   | .922   |    |      |
| AA            | 0.490 | 0.510 |                | .498                       | .498   | .498   | .497   | .499   |    |      |
| AB            | 0.178 | 0.198 |                | .188                       | .188   | .188   | .188   | .188   |    |      |
| AC            |       |       |                |                            |        |        |        |        |    |      |
| AD            |       |       |                |                            |        |        |        |        |    |      |
| AE            |       |       |                |                            |        |        |        |        |    |      |
| AF            |       |       |                |                            |        |        |        |        |    |      |
| Accept/Reject |       |       |                |                            |        |        |        |        |    |      |

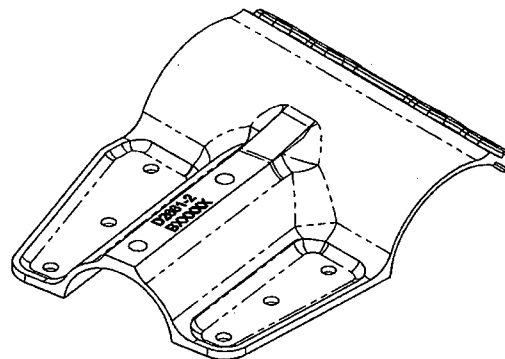
|              |          |
|--------------|----------|
| Measured by: | F.K.     |
| Date:        | 12/01/21 |

|             |          |
|-------------|----------|
| Audited by: | CMF      |
| Date:       | 12/01/23 |

| Rev | Date     | Change  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue   | RF         |          |
| B   | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF         |          |
| C   | 99.11.11 | Added Dim. R-T                                    | RF         |          |
| D   | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686         | KJ/RF      |          |
| E   | 06.07.05 | Revised per drawing revision C                    | KJ/JLM     |          |
| F   | 07.03.21 | Revised per drawing revision D                    | KJ/JLM     |          |
| G   | 11.10.13 | Dimensions C and F revised                        | KJ         |          |



**D2661-1 SADDLE, OUTSIDE, LH**



**D2661-2 SADDLE, OUTSIDE, RH**

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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 78142 M.C.J  
1112129

**RELEASED**  
R 2011-11-16

|            |   |    |          |
|------------|---|----|----------|
| E          | REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4);<br>REF NCR 11-935 | CP | 11.10.31 |
| D          | R0.188 WAS R0.30; Ø0.316 WAS Ø0.313                                   | CB | 06.11.08 |
| C          | INCORPORATE DEO 9122, 9102, 9095                                      | CB | 06.05.29 |
| B          | ANGLE AND NOTES ADDED   | KE | 97.07.11 |
| A          | NEW ISSUE   | DS | 07.03.25 |
| REV.       | DESCRIPTION   | BY | DATE     |
| DESIGN     |   |    |          |
| DRAWN      |   |    |          |
| CHECKED    |   |    |          |
| MFG. APPR. |   |    |          |
| APPROVED   |   |    |          |
| DE APPR.   |   |    |          |
| DATE       | 11.10.31  |    |          |

|  |                        |
|--|------------------------|
| <b>DART AEROSPACE USA, INC.</b><br>KENT, WA  |                        |
| DRAWING NO.<br><b>D2661</b>  | REV. E<br>SHEET 1 OF 5 |
| TITLE<br><b>SADDLE, OUTSIDE</b>  | SCALE<br>NTS           |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

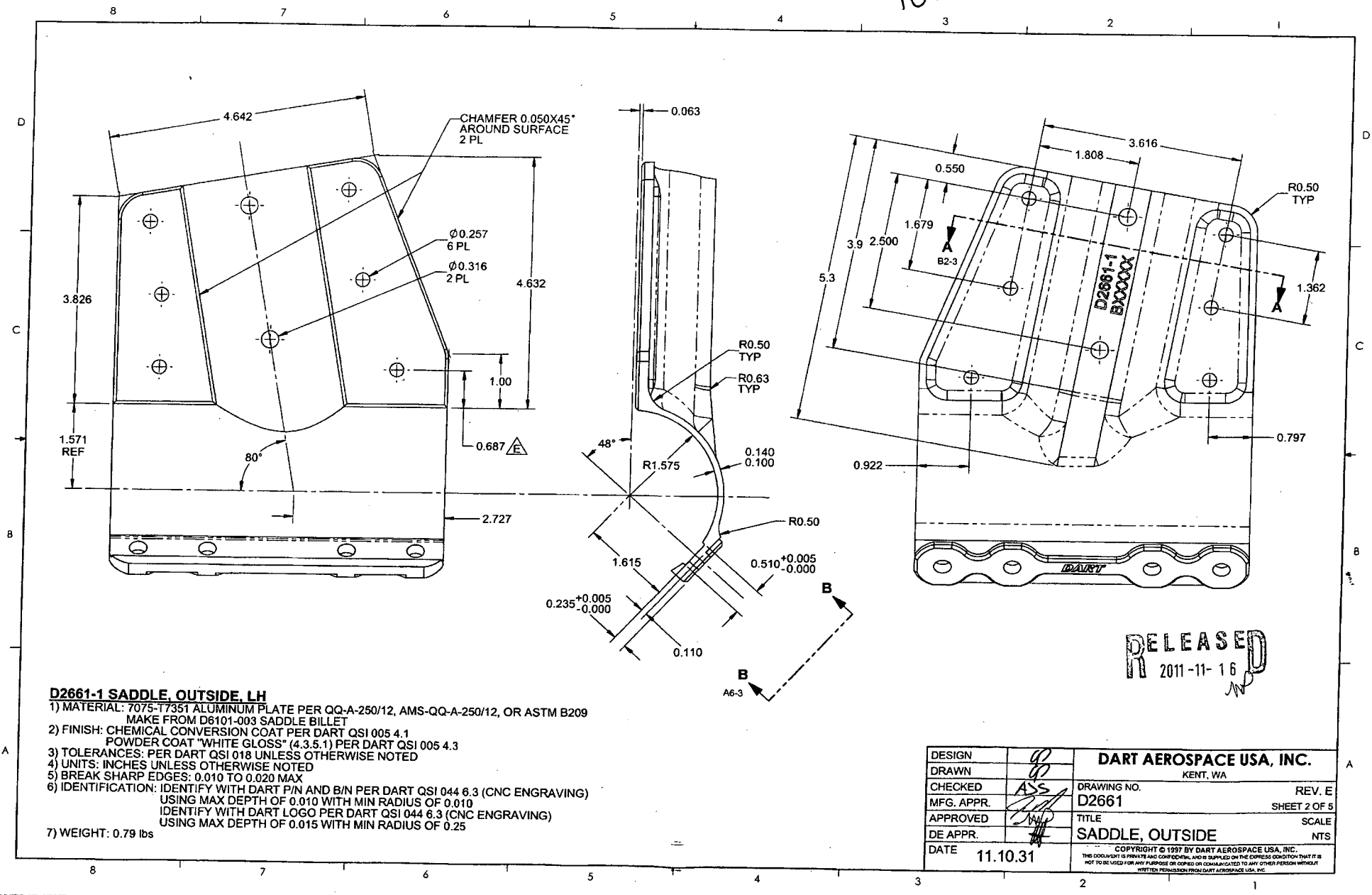
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

78142



RELEASED  
2011-11-16

**D2661-1 SADDLE, OUTSIDE, LH**

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209  
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010  
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     |          | <b>DART AEROSPACE USA, INC.</b>  |              |
| DRAWN      |          | KENT, WA   |              |
| CHECKED    | ASS      | DRAWING NO.  | REV. E       |
| MFG. APPR. |          | D2661  | SHEET 2 OF 5 |
| APPROVED   |          | TITLE  | SCALE        |
| DE APPR.   |          | SADDLE, OUTSIDE  | NTS          |
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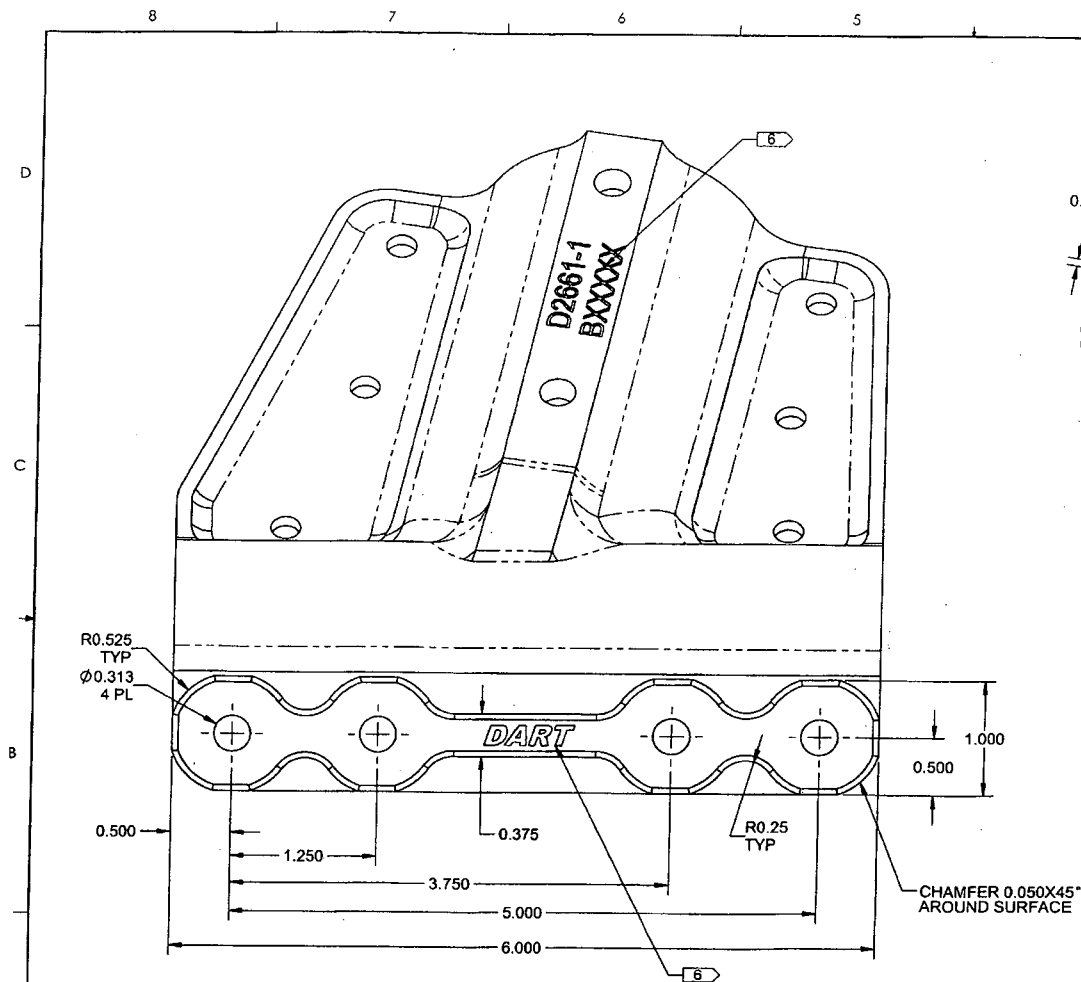
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

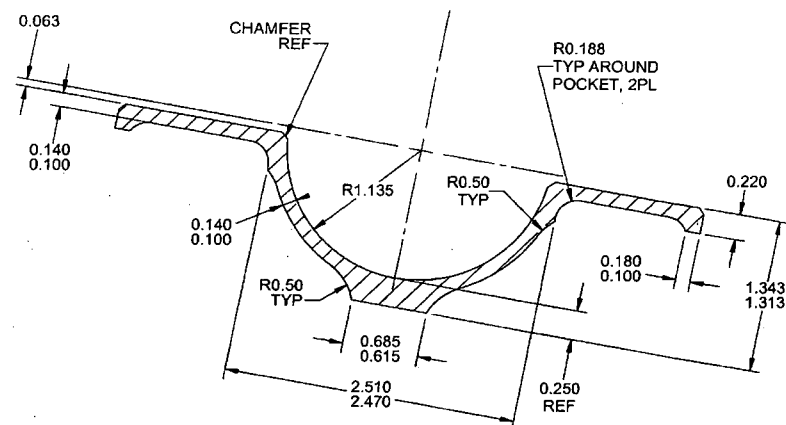
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**VIEW B-B**  
**SCALE 1.5X**  
**VIEW ROTATED**



**VIEW A-A**  
**SCALE 1.5X** C3-2

RELEASE  
2011-11-16

|            |                    |   |              |
|------------|--------------------|---|--------------|
| DESIGN     | <i>Q</i>           | <b>DART AEROSPACE USA, INC.</b><br>KENT, WA<br><br>DRAWING NO. <b>D2661</b><br><br>TITLE<br><b>SADDLE, OUTSIDE</b><br><br>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC.<br><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small> | REV. I       |
| DRAWN      | <i>Q</i>           |   | SHEET 3 OF 3 |
| CHECKED    | <i>AS</i>          |   | SCALE        |
| MFG. APPR. | <i>[Signature]</i> |   | NTS          |
| APPROVED   | <i>JAN</i>         |   |              |
| DE APPR.   | <i>H</i>           |   |              |
| DATE       | 11.10.31           |   |              |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

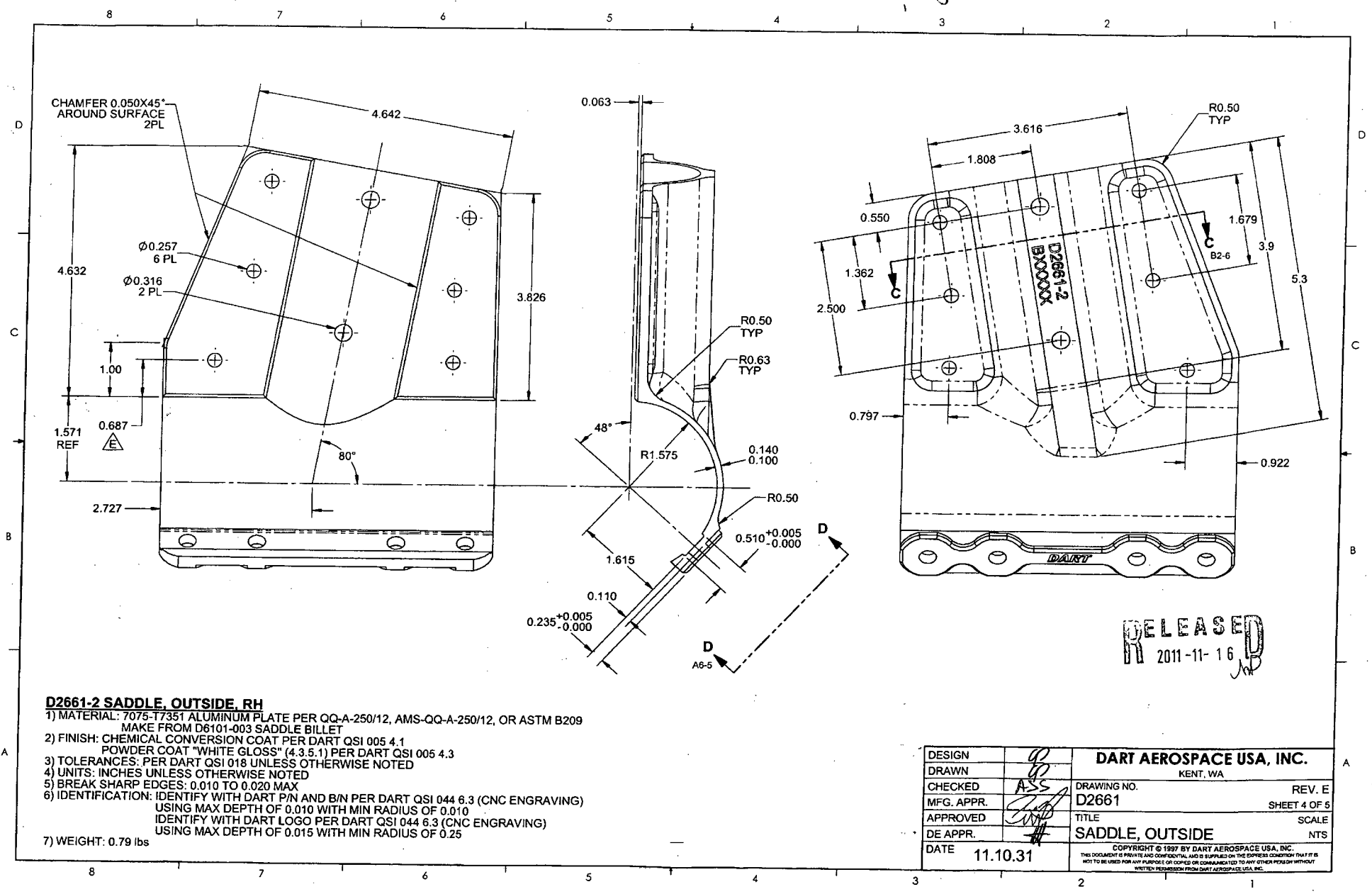
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

78142



RELEASED  
2011-11-16

**D2661-2 SADDLE, OUTSIDE, RH**

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209  
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010  
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | 90       | DART AEROSPACE USA, INC.   |              |
| DRAWN      | 90       | KENT, WA   |              |
| CHECKED    | ASS      | DRAWING NO.  | REV. E       |
| MFG. APPR. |          | D2661  | SHEET 4 OF 5 |
| APPROVED   |          | TITLE  | SCALE        |
| DE APPR.   |          | SADDLE, OUTSIDE  | NTS          |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

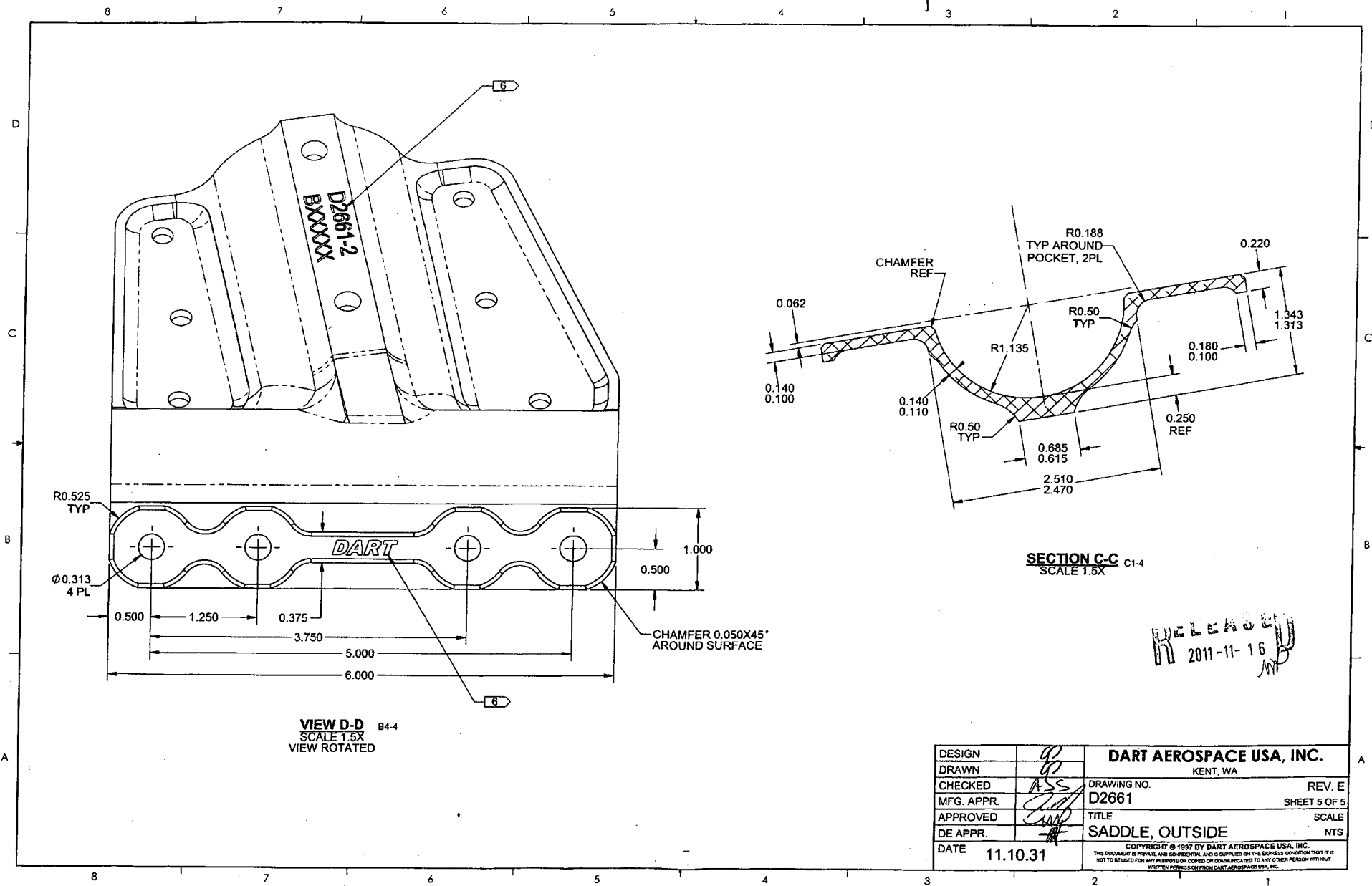
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

78142



**VIEW D-D** B4-4  
SCALE 1.5X  
VIEW ROTATED

**SECTION C-C** C1-4  
SCALE 1.5X

RELEASED  
2011-11-16

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | GP       | <b>DART AEROSPACE USA, INC.</b>   |              |
| DRAWN      | GP       | KENT, WA  |              |
| CHECKED    | ASS      | DRAWING NO.   | REV. E       |
| MFG. APPR. | SWP      | D2661   | SHEET 5 OF 5 |
| APPROVED   | SWP      | TITLE   | SCALE        |
| DE APPR.   | SWP      | SADDLE, OUTSIDE   | NTS          |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries